Work Orde				*940	909*				A	SAJ	Page 1
Item ID: Revision ID:	D3942-1			Accept	*N900	040	100)* s	etup Star	I VI	S1*
Item Name:	Angle								Stop	*N:	S2*
Start Date: Required Date:	12/24/2012 1/3/2013	Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*		Cust Item I Customer:	D:					
Reference:		,	nu		Customer.						
Approvals:	Process Pla	MF.	Date: 12-20	Tooling:	D:	ate:		R	tun Star	1/1	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:			Stop	` *N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3942	C										
100				0.00							
100 Waterjet		Memo		. 0.00				Ø		Bi_	3-1-8
FLOW CNC Waterje	et		Dwg D3942-1							•	
304,050		Dwg Rev: Prog Rev:									
		2-Deburr if n	ecessary								
110		QC2- Inspect parts off ma	achine FAI/FAIB	0.00							
110								85			1213-1-8
OC		N/		0.00				€ ::`)			バディマニエク

0.00

Memo

Quality Control

		DQA:	Date:	
ICP: Voc / No	WORK OPDER NON-CONFORMANCE / LIDDATE			

										QA Closed:	Date	· · · · · · · · · · · · · · · · · · ·
Work Order	r:				DISPOSITION				AGAINST D	EPARTMENT	PROCESS	:
Part No	o				Rework Scrap Use-as-is Work Order Update	T	herm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	- 1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Init	ial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling	7											
Operator	7											
Material	7											
Setup		İ										
Other												
Process												
Supplier												
Training												
Unapproved												
					F	AULT (ATE	GORY				
Landing	g Gear			_	General					<u> </u>		
	Bending				Bend	∐ Gr	ain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	На	ırdwa	re	L	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	specti	on Incomplete	L	Part Incorre	ct _	Weld
	Crushed/	Crimped.			Burrs	lns	struct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Шм	ainte	nance	L	Part Moved		
	Heat Trea	it			Countersink	М	islabe	led		Positioned \	_	-
	Inspection	n Strip in	Tube		Cut Too Short	М	isreac	i		Power Loss/	Surge	Other
	Ripples in				Drill Holes	\longrightarrow	fset					
	Torque W	aves in E	extrusion	ր <u> </u>	Drawing	\vdash		Calibration				
	Turning S	equence		L	Finish	∐o ₁	ut of S	Sequence				
	Wave/Tw	ist in Tul	ре		Folio	O	utside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Monday, Decem				*949	<u> </u>						Page	2
Item ID: Revision ID: Item Name:	D3942-1 Angle			Accept	*N900	<u>040</u>	100)* s	etup Start Stop	ıv.	S1* S2*	
Start Date: Required Date: Reference:	12/24/2012 1/3/2013	Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*		Cust Item I Customer:	iD:						
Approvals:	Process Pla	an:	Date:	Tooling:	D:	ate:		R	un Start	*NI	R1*	
						ate:			Stop	*NI	R2*	
Sequence ID/ Work Center II	D .	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty		Reject Number	Insp. Stamp	
120 QC Quality Control		Мето		0.00 13 158				Coun	7			-
*130				0.00				96				30
Brake NC Brake NC		Memo 1- Bend as po	er dwg D3942	0.00	· ·							V · (
¹⁴⁰ *1⊿∩*		QC5- Inspect part comple	eteness to step on W/O	0.00 15 15 13-1.9				95				
QC		Mama		0.00								-

Quality Control

NCR:	/es	/ No					WORK ORDER NON-CONFORMANCE / UPDATE							
												QA Closed:	Date	:
Nork Orde	er:						DISPOSITION				AGAINST D	EPARTMENT	PROCESS	
Part N	.lo						Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	10.	_					Work Order Update			Large Fab	Composite	, Recyston	Supplier	
Root					Des	cri	otion of work order update	I	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		C	r Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining														
							. F.	AUL	T CATE	GORY				
Landir	ng G	iear					General							
		Bending Centre No Cracks	t Concer	ntric to	O/S		Bend BOM/Route Broken/Damaged		Grain Hardwa	re on Incomplete		Ovalized Over/Under Part Incorre	—	Pressure/Forced Temperature/Cure Weld
	-	Crushed/C	Crimped.				Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/Mi	<u></u>	Wrong Stock Pulled
		Cuffs Heat Trea	t				Contamination Countersink		Mainte Mislabe			Part Moved Positioned V	Vrong	
ľ	\neg	Inspection	Strip in	Tube			Cut Too Short	Misread Power Loss/Surge Other			Other			
İ	\neg	Ripples in					Drill Holes		Offset		_			
ļ		Torque W	aves in E	xtrusio	n		Drawing		Out of (Calibration				
l		Turning Se	eauence				Finish		Out of S	equence				

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

	=======================================		3 · _ 									· ***
Work Orde				*940	30 <u>9</u> *							Page 3
Item ID: Revision ID: Item Name:	D3942-1 Angle			Accept	*N900	040	100)*	Setup	Start Stop	1 141	S1* S2*
Start Date: Required Date: Reference:	12/24/2012 1/3/2013	Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*		Cust Item I Customer:	D:					I W	
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 150 *150* Packaging Packaging)	Operation Description Identify as per dwg & Stock Memo	k Location: <u>0</u> 75	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reg	-	Reject Number	Insp. Stamp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

160

160

Quality Control

13/1/11 A) MF 09 (3.01-09

		DQA:	Date:
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator						•							
Material													
Setup]		
Other													
Process													
Supplier							1.						
Training													
Unapproved			<u> </u>				1				<u> </u>		<u> </u>
							AUL	T CATE	GORY				
Landi	_	1			_	General					7		٦
		Bending				Bend	-	Grain		-	Ovalized	. —	Pressure/Forced
	_	Centre No	ot Concer	ntric to	^{O/S}	BOM/Route	\vdash	Hardwa			Over/Under	. —	Temperature/Cure
	-	Cracks	o ·		-	Broken/Damaged	\vdash	-	ion Incomplete	,	Part Incorre	 	Weld
	-	Crushed/	Crimped.		<u> </u>	Burrs	\vdash		ions Incomplete/	Unclear	Part Lost/M	- L	Wrong Stock Pulled
	\vdash	Cuffs			_	Contamination	\vdash		enance	-	Part Moved		
	\vdash	Heat Trea		Tuba	-	Countersink	\vdash	Mislabe			Positioned \	· · · —	Other
		Inspection Ripples in		rube	-	Cut Too Short Drill Holes	\vdash	Misrea Offset		<u> </u>	Power Loss/	ouge	Tottler
		Torque W		:vtrucio	<u>,</u>	Drawing			Calibration			•	<u> </u>
	<u> </u>	Turning S			' <u> </u>	Finish			Sequence				
	H	Wave/Tw			-	Folio	\vdash		Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

Monday, December 24, 2012 11:10:54 AM

Work Order ID:

94909

Parent Item:

D3942-1

Parent Item Name:

Angle

Start Date: 12/24/2012

Required Date: 1/3/2013

Start Qty: 60.00

Required Qty: 60.00

Comments:

Ipp Rev:A UPDATE TO REV B 10-11-24 JLM VERIFIED BY:EC

Comments.	ipp Kev.A Or DA	IE IO KEV B IO	-11-24 JL	W VERIFIEL	BYEC								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	348.5299	0.015	0.9473684	11.5		
304/316 .050 Sheet								*	COMP A.		<u></u>	3-1-8	
				Location		Loc Oty	<u>Lo</u>	c Code			• -		
				MAT019		25					6		
				117	188	5					E		
				117	7766	5							
				120	0604	5							
				122	2325	5							
				123	3155	5			153	158			
				MAT020		323.529894							
				120)243	2							
				121	626	1.529894							
				124	1029	320							

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CONFOR	MANCE / UP	PDATE	QA Closed:	Date	
						T			QA Closed:	Date:	
Work Orde	ar.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE	···				Rework	1 !	Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.				Scrap	1 1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			· · · · · · · · · · · · · · · · · · ·		Use-as-is	Ther	moforming	Finishing	4	re/Packaging	Other
NCR N	lo				Work Order Update]	Large Fab	Composite	1	Supplier	
Root				Descri	otion of work order update	Initial	Ad	ction	Sign &		1
Cause	Date	Step	Qty	C	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling								•			
Operator											
Material											
Setup											·
Other											
Process		1									
Supplier				:				•• .			
Training											·
Unapproved							<u> </u>				
					F	AULT CAT	EGORY		-		
Landir	ng Gear				General				-		7
	Bending				Bend	Grain		<u> </u>	Ovalized	_	Pressure/Forced
	Centre No	ot Concei	ntric to	o/s	BOM/Route	Hardw		<u> </u>	Over/Under	 	Temperature/Cure
,	Cracks			L	Broken/Damaged	\vdash	tion Incomplete		Part Incorre	├	Weld
	Crushed/	Crimped.			Burrs	—	ctions Incomplete	/Unclear	Part Lost/M		Wrong Stock Pulled
ļ	Cuffs				Contamination		enance	_	Part Moved		
	Heat Trea				Countersink	Mislab			Positioned \		7
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	ad		Power Loss,	/Surge	Other
	Ripples in	n Bend			Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	94909
Description: Angle	Part Number:	D3942-1
Inspection Dwg: D3942 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x	First Article	Prototype
---	---------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.06	+/-0.030	3,665	٤		V Br	
0.75	+/-0.030	753	L.		V	
Ø0.129	+0.005/-0.001	133	2		V	
0.75	+/-0.030	רזר,	上		V	-
0.25	+/-0.030	. 251	2		ν	
0.25	+/-0.030	, 251	٨		r	
0.25	+/-0.030	, 351)		V	
0.35	+/-0.030	353	یر		V	
			- DAG			

Measured by: R Audited by: 15 Prototype Approval: N/A

Date: 13-1-9 Date: 13-1-8 Date: N/A

Rev	Date	Change	Revised	þ	У	Approved
Α	09.06.22	New Issue	KJ 9	₹	<u> </u>	AU
				7		

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE																
									-		QA Closed:	Date	: :			
Work Order:						DISPOSITION	AGAINST DEPARTMENT/PROCESS									
Part No						Rework Skid-tube Crosstube Scrap Machining Small Fab Thermoforming Finishing Work Order Update Large Fab Composite				-{	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root					Descri	iption of work order update		Initial	Action		Sign &					
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector			
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved																
						F	AUL	LT CATE	GORY							
Landi		1	~			General		1		_	7	Г	¬-			
	-	Bending Centre No	ot Concer	ntric to	o/s	Bend BOM/Route		Grain Hardware			Ovalized Over/Under	tolerance -	Pressure/Forced Temperature/Cure			
	\vdash	Cracks				Broken/Damaged	L	- '	on Incomplete	L	Part Incorre	<u> </u>	Weld			
	\vdash	Crushed/	Crimped.			Burrs		-1	ions Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled			
	Ш	Cuffs				Contamination		Mainte			Part Moved					
		Heat Trea	it			Countersink		Mislabe	led		Positioned \	Wrong _				
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	'Surge	Other			
	Ripples in Bend					Drill Holes Offset					_	_				

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

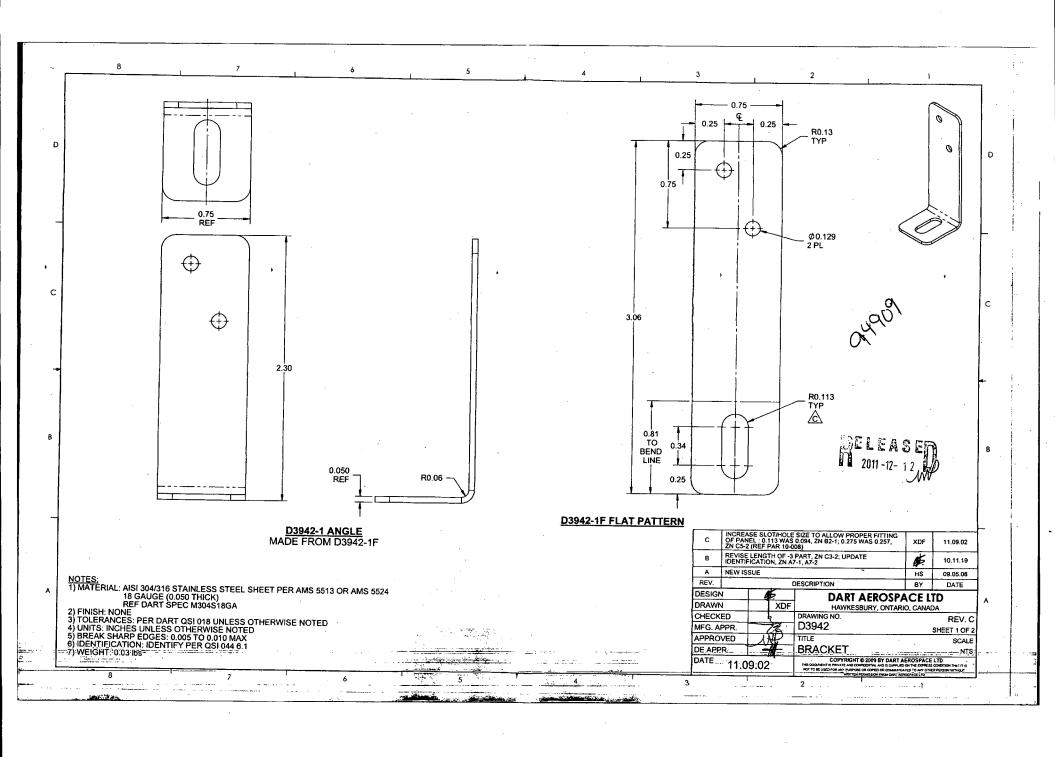
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

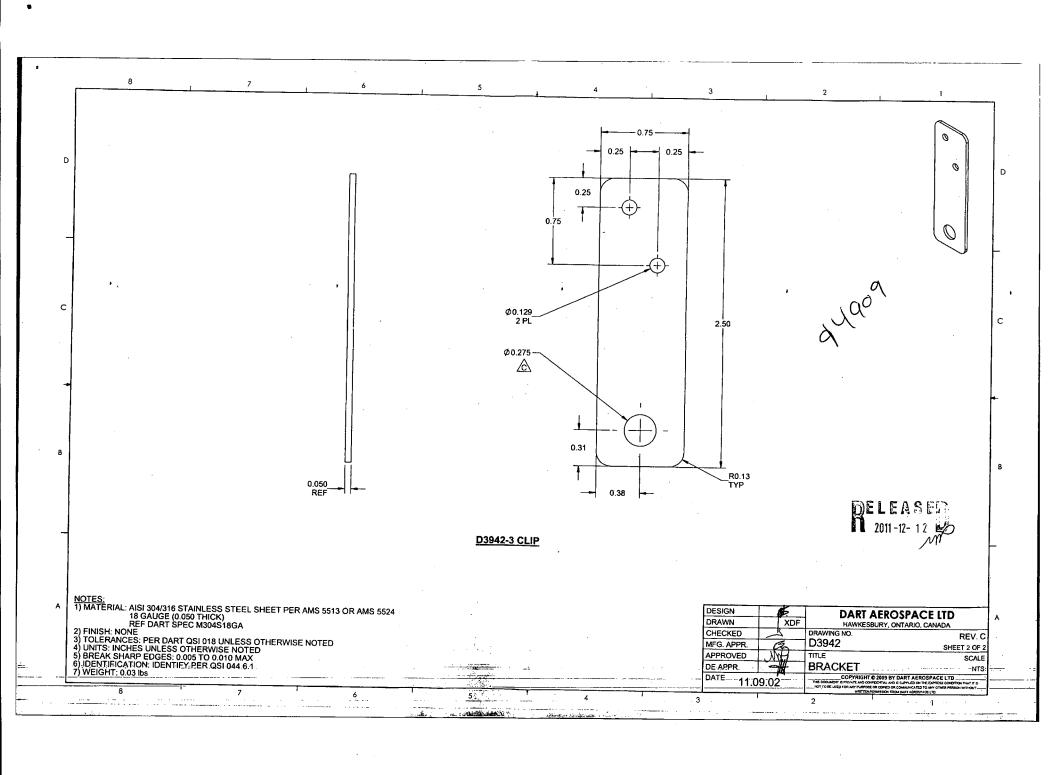
Finish



				DQA:	Date:
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		

											QA Closed:	Date	:
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT		
Part No						Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing			Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	. Ad	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator									ļ				
Material	Ш												
Setup	Ш										1		
Other	Ш												
Process			ļ							,			
Supplier								•					
Training					:								
Unapproved			<u> </u>			11 1					L	1	
							AUL	T CATE	GORY				
Landi	_	ì			_	General	_	Grain			1	Г	- , ,
1	-	Bending			_					-	Ovalized	-	Pressure/Forced
	\vdash	Centre Not Concentric to O/S				BOM/Route	\vdash	Hardwa			Over/Under	⊢	Temperature/Cure
	\vdash	Cracks				Broken/Damaged	-	1	ion Incomplete	<u> </u>	Part Incorre)	Weld
	Crushed/Crimped.				<u> </u>	Burrs	\vdash	4	tions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				<u> </u>	Contamination	\vdash	ł	enance	_	Part Moved	•••	
	\vdash	Heat Treat Inspection Strip in Tube				Countersink	\vdash	Mislab		<u> </u>	Positioned \	_	,
	-			rupe	<u> </u>	Cut Too Short	\vdash	Misrea	a	<u> </u>	Power Loss,	Surge	Other
	-	Ripples in			_	Drill Holes	-	Offset	Calibration				
	H	Torque W			1	Drawing Finish	\vdash	4					
	\vdash					Finish Out of Sequence Folio Outside Dimensions							
	L IWave/I wist in Tube L l Holio												

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



						<i>,</i> ·						DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE					
												QA Closed:	D	ate:	
Work Ord	er.					DISPOSITION				AGAINST [ÞΕ	PARTMENT,	/PROCESS		
Work Ord	-					Rework]		Skid-tube	Crosstube]	Water Je	t 🔲	Engineering
Part I	۷o					Scrap		I	Machining	Small Fab		4	d. Eng. Coor	-	Quality
NCR No.						Use-as-is Thermoforming Work Order Update Large Fab				Finishing Composite					
Root	Т	·			Descri	tion of work order update	Τ	Initial	Ac	tion	_	Sign &			
Cause		Date	Step	Qty	1	or Non-conformance	1	nief Eng		ription		Date	Verificati	on	QC Inspector
Doc/Data								,		····					1
Equip/Tooling												<u> </u>	•		
Operator															
Material	Ш											!			
Setup	Ш						1				ĺ				
Other	Ш														
Process											,				
Supplier	Ш						İ								
Training															
Unapproved	Ш														
FAULT CATEGORY															
Landi					_	General		,		-	_	-			•
	Bending					Bend		Grain			_	Ovalized			Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route	<u>_</u>	Hardwa	lware .		_	Over/Under	tolerance	<u> </u>	Temperature/Cure
	\vdash	Cracks				Broken/Damaged		Inspecti	on Incomplete	Ĺ	_	Part Incorrect			Weld
	—	Crushed/0	Crimped.			Burrs		4	ions Incomplete/	Unclear		Part Lost/M	issing		Wrong Stock Pulled
	Cuffs					Contamination Maintenance						Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G